

# Work Order ID 60509

Tuesday, July 13, 2010 10:06:16 AM



Page 1

Item ID:	D3204-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Release Pedal Assembly					
Start Date:	7/13/2010	Start Qty:	4.00		Cust Item ID:	
Required Date:	7/20/2010	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	10-7-10	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3204	Rev A1

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- Weld assembly as per Dwg D3204 using Jig D3204-041T1. □2- Drill #40 diameter hole in the center of Ø0.760" c'bore on D3204-5 arm prior to weld. □3- Use JB weld compound to plug the hole after assembly. □4- Grind JB weld flush after it is cured. □Ident								

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

4x

Cpl 101005

4x - BE 10-10-06

4x

S 1010106

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



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Revision ID:   
Item Name: Release Pedal Assembly Stop   
Start Date: 7/13/2010 Start Qty: 4.00  Cust Item ID:   
Required Date: 7/20/2010 Req'd Qty: 4.00  Customer:   
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00	<i>DL 10-10-7.</i>			<i>(4)</i>			
140  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>M112588</i> Memo ***Cover holes for bushing*** 10:10 <input type="checkbox"/> OVEN TEMPERATURE: <i>320°</i> <input type="checkbox"/> FINISH TIME: <i>12:50</i>	0.00 0.00	<i>DL 10-10-7.</i>			<i>4.</i>			
150  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00	<i>Sidhu</i>			<i>(4)</i>			

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Cust Item ID:

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Customer:

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Install D3204-7 bushing as shown in Dwg D3204

8/10/08 (4)

170

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

8/10/08

(74)

180

0.00



Identify as per dwg &amp; Stock Location: 197

Packaging

Memo

0.00

Packaging

10/10/12 sl (42)

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/12 AG  
mf  
10-10-12

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# Picklist Print

Tuesday, July 13, 2010 10:06:26 AM

Page 1

Work Order ID: 60509

Parent Item: D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 7/13/2010

Required Date: 7/20/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: ☐ C ☐ 05.08.11 ☐ Added Step 25 ☐ KJ/JLM ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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✓ D3204-1 Tube		Manufactured	No			100	Each	5.0000	1	4			
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Location	Loc Qty	Loc Code
WA20	5	

✓ D3204-11 Plate		Manufactured	No		57547	100	Each	44.0000	1	4			
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Location	Loc Qty	Loc Code
ST45	14	
57522	14	
WA	30	
55463	30	

✓ D3204-3 Arm		Manufactured	No			100	Each	9.0000	1	4			
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Location	Loc Qty	Loc Code
WA	9	
57737	9	

✓ D3204-5 Arm		Manufactured	No			100	Each	8.0000	1	4			
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Location	Loc Qty	Loc Code
WA	8	
57738	8	

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Page 2

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Parent Item: D3204-041

Parent Item Name: Release Pedal Assembly

Start Date: 7/13/2010

Required Date: 7/20/2010

Start Qty: 4.00

Required Qty: 4.00

D3204-7

Manufactured No

100 Each

13.0000

2

8



Bushing

Location

Loc Qty

Loc Code

ST045

13

48631

13

Manufactured No

100 Each

5.0000

1

4

✓ D3204-9



Pedal

Location

Loc Qty

Loc Code

WA

5

43765

5

Manufactured No

160 Each

29.0000

2

8

∫ D3204-13



Gusset

Location

Loc Qty

Loc Code

WA

29

55365

1

58211

28

*Cpl 10/19/04*  
*10/10/25*

*8*

*10/09/30*

*4x*

*10/09/30*

*7*

Tuesday, July 13, 2010 10:06:26 AM

Shop Packet Print

Page 2

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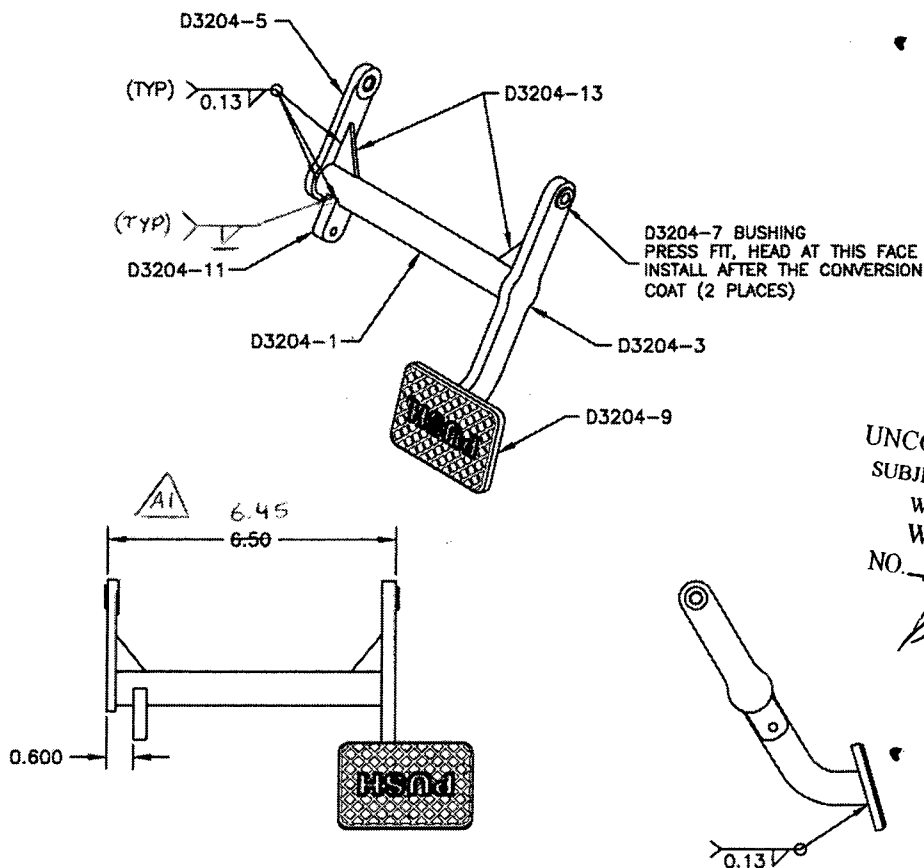
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27	TITLE RELEASE PEDAL ASSEMBLY		SCALE NTS
A	04.01.27	NEW ISSUE	
AI	05.07.15	6.45 WAS 6.50	

RELEASED  
04.04.30



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WITHOUT NOTICE  
WORK ORDER  
NO. 40509  
P10-713

### D3204-041 RELEASE PEDAL ASSEMBLY

#### NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020  
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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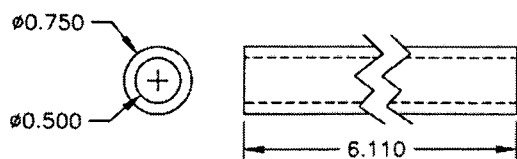
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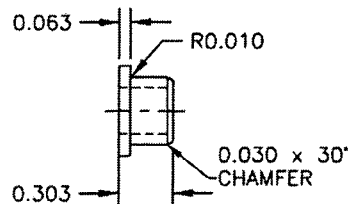


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

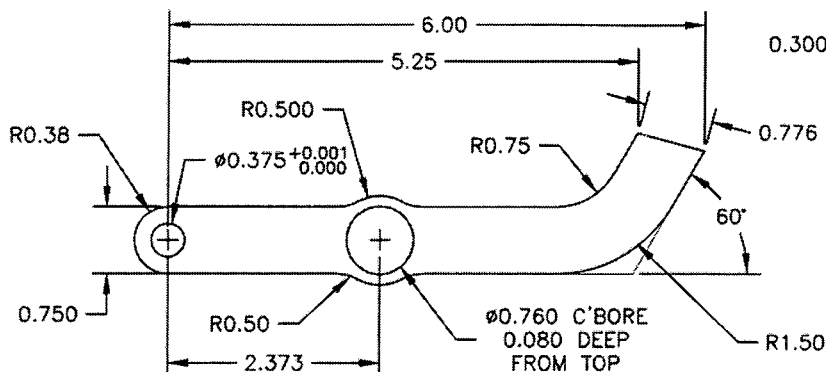
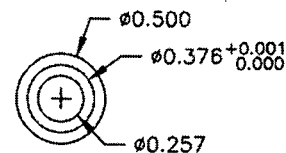
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04.04.05



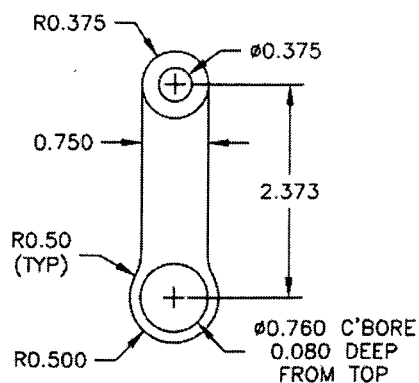
2 D3204-1 TUBE  
SCALE 1:2



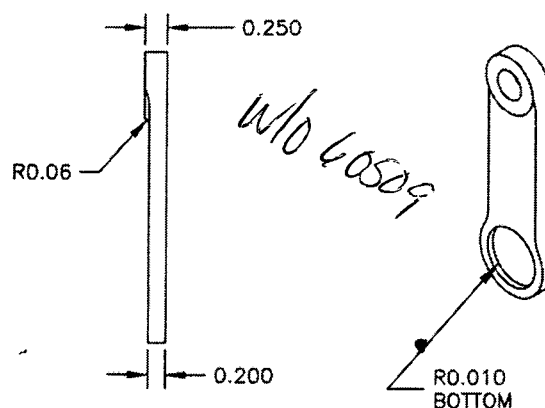
4 D3204-7 BUSHING  
SCALE 1:1



3 D3204-3 ARM  
SCALE 1:2



3 D3204-5 ARM  
SCALE 1:2



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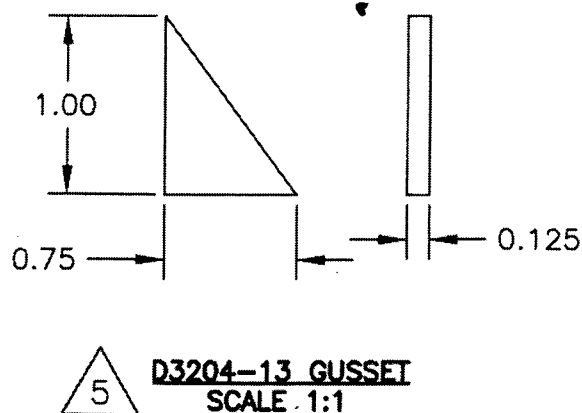
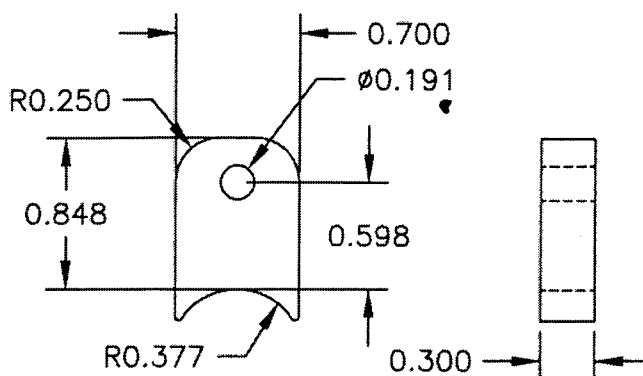
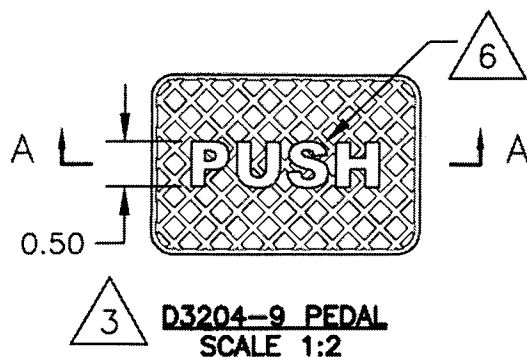
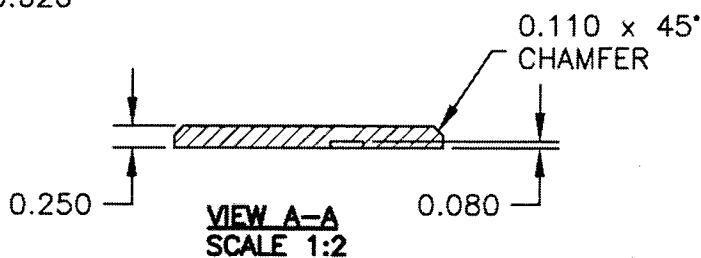
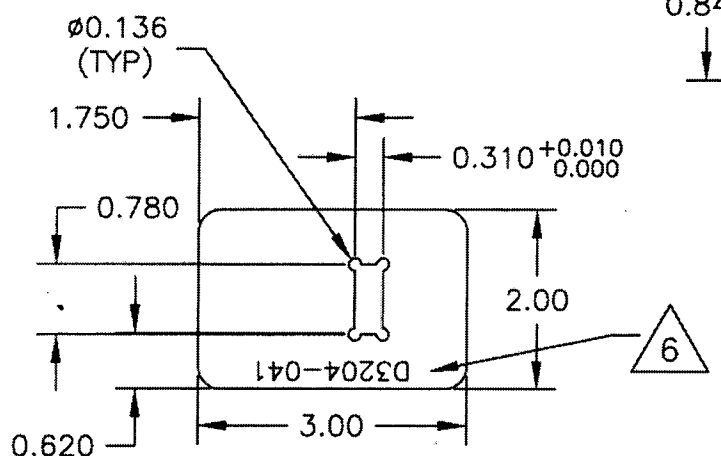
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04.04.30



w/6 60509

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